

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015992**Date Inspected:** 08-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (A, B, C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion corner joint between Side plate to Edge Plate of segment 11BW. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area.

The Weld Designation is as follows

SEG067A-040,041

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 11BW joints.

The welds designation reviewed are as follows:

WELDING INSPECTION REPORT

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SEG067*-007,009~023,036~040
SEG067A-005,011,020,031
SEG067B-002,003,025,033,053,054
SSD11A-PP99-185
SSD11-PP99-007
SP504-001-034,035
SP741-078~080
SP742-001-037
FB19A-001-164,165
FB27B-001-164,165

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 11BW, this Quality Assurance Inspector (QA) discovered the following issues that four (4) longitudinal linear class "A" rejectable indications measuring approximately 15mm~35mm in length. The welds are identified as SEG067*-008,012,024,035. Material thickness for all joints is 14mm. The indication db rating is a +2 to +9. The depth of the indications are approximately 5mm~10mm. The welds SEG067*-008,012,035 are at Panel Point PP98 and SEG067*-024 is at Panel Point PP100. The welds are Complete Joint Penetration (CJP) butt joint. The joints are joining between Deck Plate Diaphragm (X1B) to Deck Plate Diaphragm (X1B). The welds are designated as Non Seismic Performance Critical Material (Non SPCM). The indications are clearly marked on or near the weld. Segment 11BW is located at Back side of Bay 13. The Notice of Witness Inspection (NWIT) No. is 006125. The indication for joint SEG067*-008 is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel and remaining joints SEG067*-012,024,035 are located at outside of tested area by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform Twenty Five (25%) percent UT inspection of those welds.

The QA Inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
